

Work Order ID 131536

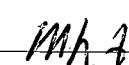
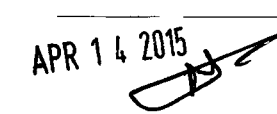
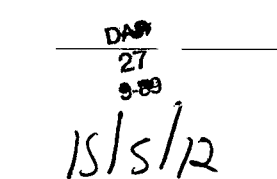
Tuesday, April 14, 2015 10:05:16 AM

131536

April 30th - Page 1

Item ID: DSI 9268-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Volume Increase Modification
 Start Date: 4/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/21/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 5-4-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9268	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP DSI 9268-011 CHG 004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
15/5/12

APR 14 2015

DAS
27
9-89
15/5/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 131536

Tuesday, April 14, 2015 10:05:16 AM

131536

Page 2

Item ID: DSI 9268-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Volume Increase Modification
 Start Date: 4/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/21/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9268-011								
	Location: _____								
	PPP rev: _____								
	<i>Ship</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MAY 12 2015

DAS
6
9-89

MLJ

MAY 12 2015

MF

15-5-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : ☐																									

Picklist Print

Tuesday, April 14, 2015 10:05:15 AM

Page 1

Work Order ID: 131536

131536

Parent Item: DSI 9268-011

DSI 9268-011

Parent Item Name: Basket Volume Increase Modification

Start Date: 4/14/2015

Required Date: 4/21/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC IPP
REV:E 15.03.26 AS PER DSI REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-21A Bolt		Purchased	No			110	Each	52.0000	5				
-----------------	--	-----------	----	--	--	-----	------	---------	---	--	--	--	--

Location	Loc Qty	Loc Code
ST325A	50	
m131139	50	
ST342	2	
m127817	2	

D3230-041		Manufactured	No			110	Each	0.0000	1				
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

D3230-041 Basket Wedge Assembly													
------------------------------------	--	--	--	--	--	--	--	--	--	--	--	--	--

D5225-1		Manufactured	No			110	Each	0.0000	5				
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

D5225-1 Spacer													
-------------------	--	--	--	--	--	--	--	--	--	--	--	--	--

DSI 9053-011		Manufactured	No			110	Each	2.0000	1				
--------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

DSI 9053-011 Hinge Change													
------------------------------	--	--	--	--	--	--	--	--	--	--	--	--	--

Location	Loc Qty	Loc Code
FG123	2	
105169	1	
115475	1	

APR 14 2015

MAY 12 2015

APR 27 2015

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DAS
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9-89

5 M.P.

1 x B131538

131539

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____				MRB (QS1042) Approval																	
Description Work Order Deviation		Disposition				Completed By																	
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Picklist Print

Tuesday, April 14, 2015 10:05:15 AM

Page 2

Work Order ID: 131536

131536

Parent Item: DSI 9268-011

DSI 9268-011

Parent Item Name: Basket Volume Increase Modification

Start Date: 4/14/2015

Required Date: 4/21/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

1,650.000

\$

5

MS21042L4

**

Locknut

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

574

m127813

574

ST260a

491

m130799

56

m131803

435

ST305

543

426

426

m128300

8

m130922

97

m131618

12

DAS
27
9-09

APR 14 2015

5 M.T.

NAS1149D0463J

Purchased

No

110

Each

896.0000

\$

5

NAS1149D0463J

**

WASHER

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

855

M129682

397

M130799

458

DAS
27
9-09

5

12 M.P.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY						
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

Ref only

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J

REF. CANADIAN STC: SH96-120

REF. FAA STC: SR00696NY

EASA STC: EASA.IM.R.S.01242

THE PURPOSE OF THE DSI 9268-011 BASKET MODIFICATION KIT IS TO INCREASE THE VOLUME OF THE D205-541-043/-044 BASKETS. NOTE THAT D205-541-041 BASKETS MUST BE CONVERTED INTO D205-541-043/-044 PER DSI 9226 BEFORE PERFORMING THIS MODIFICATION.

TO INSTALL THE DSI 9268-011 KIT:

- 1) FOR BASKETS WITH:
 - A) PIANO HINGES: INSTALL THE DSI 9053-011 HINGE CHANGE KIT AND SEPARATE LID FROM BASE.
OR
 - B) DSI 9053-011 HINGE CHANGE KIT ALREADY INSTALLED: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
OR
 - C) HINGE PLATES WELDED TO LID & BASE: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
- 2) ATTACH LID TO D3230-041 BASKET WEDGE ASSEMBLY. MOVE D2332-041 PROP ASSEMBLY FROM BASKET BASE TO WEDGE ASSEMBLY PER FIGURE 1.
- 3) LOCATE D3230-041 BASKET WEDGE ASSEMBLY COMPLETE WITH BASKET LID ON THE EXISTING BASKET BASE. ALIGN THE BACK EDGE AND TEMPORARILY CLAMP IN PLACE.
- 4) TRANSFER LOCATION OF 1/4" ATTACHMENT HOLES FROM WEDGE TO EXISTING BASE.
- 5) REMOVE WEDGE AND DRILL Ø0.266" HOLES THROUGH THE EXISTING BASE. DEBURR HOLES.
- 6) INSTALL WEDGE USING AN4-21A BOLTS, D5225-1 SPACERS, AN960JD416 WASHERS, AND MS21042L4 NUTS PROVIDED (5 PLACES TOTAL). NOTE THAT THE BOLTS IN SOME LOCATIONS MAY HAVE TO BE INSTALLED WITH THE NUTS ON TOP BECAUSE OF CLEARANCE ISSUES. CHECK FOR PROPER LATCHING OF THE EXISTING LID WITH THE WEDGE. SHIM AS REQUIRED TO ADJUST HEIGHT OF WEDGE ASSEMBLY TO ENSURE PROPER LATCHING.
- 7) ADJUST WEIGHT AND BALANCE AS FOLLOWS:

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
DSI 9268-011	20 lb	± 63.13 in	± 1263 in-lb	132.25 in	2645 in-lb
BASKET MODIFICATION KIT	9 kg	± 1.60 m	± 14.4 m-kG	3.36 m	30 m-kG

DSI 9268-011 KIT PARTS LIST:

QTY	P/N	DESCRIPTION
X	DSI 9268-011	BASKET MODIFICATION KIT
1	D3230-041	BASKET WEDGE ASSEMBLY
5	D5225-1	SPACER
1	DSI 9053-011	HINGE CHANGE KIT
5	AN4-21A	BOLT
5	AN960JD416	WASHER
5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.02.23
CERT. NO.: SH96-120
ISSUE NO.: 3

D	ADD D5225-1 SPACER, AN4-21A BOLT WAS AN4-17A BOLT, REVISE INSTRUCTIONS TO IMPROVE FIT/FUNCTION REASON: NCR15-4557	DB	15.02.23
C	UPDATED TO CURRENT DWG STANDARDS; REVISED INSTALLATION STEP #1. CORRECTED TYPO (DSI 9053-011 WAS DSI 9052-011). REASON: REDESIGN OF D3230-041 (REF. NCR#09-010).	MB	09.02.02
B	CHANGE ORIENTATION OF WEDGE	CP	03.11.19
A	NEW ISSUE	CP	03.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	N/A	DSI 9268	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION KIT	NTS
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